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DNN N1998-290128 DNC C1998-112950  
TI Continuous hot rolling for manufacturing **steel** sheet with thin  
scale - involves **coiling steel** sheet obtained from  
**finish rolling** carried out at ultimate prolonged  
pressure and predetermined speed after **quenching** at  
predetermined temperature.

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CYC 1

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The hot rolling method involves removing primary scale during  
**rough rolling**. At least one time inversion of  
**rough rolled** sheet front to back is done between  
subsequent rolls. After turning the edges of front and back of preceding  
and following **rough rolled** sheets a front to rear  
inversion is done before welding and **finishing rolling**  
after welding. The final stages of **finishing roll** is  
done using high speed **steel** rollers for active online  
**roll grinding**. **Finishing roll** is done at an  
ultimate prolonged pressure and speed of 800 m/min. **Coiling** is  
effected after **quenching** at 550-360 deg. C.

ADVANTAGE - Produces thin scale **steel** sheets.

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